Work Orde		94		*950				Page 1			
Revision ID:	D2037-101			Accept	*N900	040	100)* Se	etup Star Stop	I ZI -	S1*
Item Name: Start Date: Required Date: Reference:		Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item 1 Customer:	ID:				· ····································	57"
Approvals:		: <u>ML</u> 5	Date: <u> 3-0 -(</u>	Date:			R	un Stai Sto	17	*NR1* *NR2*	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr									
D2037	D	: :									
*100 *100* Brake NC Brake NC		NC BRAKE Memo Punch as pe	т Dwg D2037. Keep hole	0.00 0.00 distance 45.50" using Jig	D2037-101T1			6	a	<u>/3-3-</u>	/
*110 *110* Small Fab Small Fab			323" holes in D2037-101 t 337-101 tube as required u required		2-Flatten			6	<u> </u>	13-3-1	<i></i>
*120 *120* QC Quality Control		QC5- Inspect part comp	•	0.00	3-1			5			

			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	
			OA Clasadi

									QA Closed:	Date	:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	· · · · · · · · · · · · · · · · · · ·
	Rework Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier							Engineering Quality Other			
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	,	or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data								•			
Equip/Tooling											
Operator					•	:				•	•
Material		ı							,		•
Setup											
Other											
Process											
Supplier											
Training	_										
Unapproved			<u>.</u>								
						AULT CATE	GORY		•		
Landin F	 1			Γ-	General			_	1	_	¬
-	Bending			<u> </u>	Bend	Grain			Ovalized		Pressure/Forced
-	Centre No	ot Concer	ntric to	^{O/S}	BOM/Route	Hardw		_	Over/Under		Temperature/Cure
-	Cracks	· .		<u> </u>	Broken/Damaged	\mathbf{H}	ion Incomplete		Part Incorre	<u> </u>	Weld
-	Crushed/0	Crimped.		<u> </u>	Burrs	\vdash	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
-					Contamination		enance	-	Part Moved	• • • • • • • • • • • • • • • • • • • •	
-	Heat Trea		Tub-	<u> </u>	Countersink	Mislab		<u> </u>	Positioned V		Jothan
}	Inspection Ripples in	•	rube		Cut Too Short Drill Holes	Misrea Offset	u		Power Loss/	ourge	Other
-	Torque W		vtrucio	ຸ ⊢	Drawing	\vdash	Calibration				
}	Turning S			'' <u> </u>	Finish	Out of Calibration					
 	Wave/Tw			-	Folio	_	Out of Sequence Outside Dimensions				.
1	1		1	1	1 1 2 4 5 1 4						

_Date: ___

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ordo		094		*950			Page 2				
Item ID: D2037-101 Revision ID: Item Name: Arm				Accept	*N90004010) () *		up Start Stop	14721		
Start Date: Required Date: Reference:	1/02/13 : 1/11/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:						
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):	Date:	<u> </u>		Start Stop	*NR1* *NR2*		
Sequence ID/ Work Center I 130 *130* Packaging Packaging	D	Operation Description Identify as per dwg & St	ock Location: <u>w &</u> go)	Set Up/ Run Hours 0.00	Tool ID Tool # Plai Cod		ept Reje Qty		Reject Insp. Number Stamp		
*140 *140* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00			MLJ		3-03-01 MC573-03-6		

NCR: Y	ullet												
						<u> </u>		i			QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Nork Orde						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
VOIK OIGE				·		Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part N	ln					Scrap	!			Small Fab	Proc	d. Eng. Coor.	Quality
	· · · –					Use-as-is	1	i e	Machining noforming	Finishing	l	e/Packaging	Other
NCR N	lo.					Work Order Update	1	1	Large Fab	Composite	,	Supplier	
						,	1			· L			
Root					Desc	cription of work order update	1	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data	_												
quip/Tooling	_												
perator	4	- 1											
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etup	_												
ther	_				,								
rocess	\dashv												
upplier raining	\dashv												
napproved	\dashv												
approved							FAUL	T CATE	GORY		<u></u>		
Landii	ng Ge	ear				General							
1		Bending			Γ	Bend		Grain			Ovalized		Pressure/Forced
	C	entre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	c	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct 🗌	Weld
	c	Crushed/C	Crimped.			Burrs		Instruct	ioris Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	\Box c	Cuffs				Contamination		Mainte	nance		Part Moved		
	+	leat Treat	t			Countersink	L	Mislabe	led		Positioned V	Vrong	- ,
	_	nspection		Tube	<u></u>	Cut Too Short		Misread	i	L	Power Loss/	Surge	Other
ļ	_	Ripples in			L	Drill Holes		Offset					
ļ	_	orque W			ո	Drawing	<u> </u>	4	Calibration				
	Turning Sequence Finish Ou						Out of Sequence						

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-02-13 1:46:11 PM

Work Order ID:

95094

Parent Item:

D2037-101

Parent Item Name:

Arm

Start Date: 1/02/13

Required Date: 1/11/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 05-11-01 JLM

IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049	A	Purchased	No			110	<u>f</u>	457.0240	3.916	8.244210	16,		
304 RD Tube .750 x .049V	V									(/3-	5-/		
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT017		457.0240325							
				109	314	18.666							
				111	619	6							
				112	2187	8							
				120)441	0.008734							
				121	170	234.89							
				121	1666	15.134							
				122	2312	64.43							
				122	2468	109.895299							

124768x 201

									DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE								
	***								QA Closed:	Date:			
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orac	··				Rework		Skid-tube	Crosstube		Water Jet	Engineering		
Part N	lo.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	lo	·			Work Order Update		Large Fab	Composite		Supplier			
Root		1	1	Descri	ption of work order update	Initial	Α	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng		scription	Date	Verification	QC Inspector		
Doc/Data		1						•					
Equip/Tooling							İ						
Operator							1						
Material													
Setup													
Other				İ			ļ						
Process	, ·	ļ											
Supplier	_						1						
Training													
Unapproved		<u> </u>	<u>l</u>			<u> </u>	<u> </u>						
				·	· · · · · · · · · · · · · · · · · · ·	AULT CATE	EGC ^I RY						
Landin	ng Gear				General				1		7_		
-	Bending			<u> </u>	Bend	Grain		<u> </u>	Ovalized		Pressure/Forced		
-	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw		_	Over/Under	 	Temperature/Cure		
}	Cracks			<u> </u>	Broken/Damaged		tion Incomplete	<u></u>	Part Incorre		Weld		
}	Crushed/	Crimped.	-	<u> </u>	Burrs		Instructions Incomplete/Unclear			issing	Wrong Stock Pulled		
-	Cuffs			<u> </u>	Contamination	—	enance	<u> </u>	Part Moved				
-	Heat Trea			-	Countersink	Mislab			Positioned \		70.4		
	Inspection Strip in Tube				Cut Too Short	l lMisrea	ıa	1	Power Loss	/Surge	Other		

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

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V 11 95094 MLJ 13-01-03 D2037-101 ARM С REDRAWN, 0.386 WAS 0.375.

NOTES: 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, ϕ 0.750 x 0.049 WALL REF. DART SPEC M304TR0.750W.049

REF. DART SPEC M304TR0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.50 lbs
8) FOR FURTHER INFO SEE DRAWING D2638.

INCORPORATED C1.C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SOUARE BRO" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST. AJS 08.05.08 RF 99.06.07 В -103 DELETED JB 93.04.20 Α NEW ISSUE JB 91.10.22 REV. DESCRIPTION BY DATE

DESIGN	10	D 4 DT 4 FD 0	00405155			
DRAWN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	55	DRAWING NO.	REV. D			
MFG. APPR.	7.72	D2037	SHEET 1 OF 2			
APPROVED	Word	TITLE	SCALE			
DE APPR.	7	ARM	NTS			
DATE 08.	05.08	COPYRIGHT © 1991 BY DART AEROSPACE LTD THIS DOCUMENT AND COMPONITUL AND IS SUPPLIED OF THE EXPRESS CONDITION THAT IT IS NOT TO SE USED FOR ANY PARPOSE OF COMPONE ON THE CAPTER OF THE PRISON WITHOUT				

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